

20-7848



Dart Aerospace Ltd.
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Canada

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D2920-1**Job Sheet 202869****Part No:** D2920-1**Job Qty:** 4 pcs *3BL*
*3pcs***Part Name:** Inner Saddle (Aft LH)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/5/19**Job Tracking No:****Due Date:** 12/23/19 *12/15***Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG D2920 REV.B IPP Rev. A 19.10.28 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	12/23/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		<i>18 19/12/10</i>
							HAAS - 4		
100	HAAS 4 Axis	4 pcs	12/23/19		2.00	7.50	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B	<i>5BL</i>	<i>19/12/12</i>
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	4 pcs	12/23/19		0.00	0.53	Conventional Mill - 1 - B4B		<i>5BL 19/12/12</i>
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs <i>3BL</i>	12/23/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		

**Container No:** S239186**Part:** D2920-1**Job No:** 202869**Serial No/Batch:** S239186**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 12/10/19

Plex 11/5/19 7:57 AM Dart.lajeunesse.marie

130 QC 8	4 pcs	12/23/19	0.00 0.00	QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	SBL 19/12/12
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	19/12/13
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	12/23/19	0.00 0.19	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	DEC 16 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	

						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
145	QC 3	4	12/23/19	0.00	0.00	QC 3 - 10	
	pcs					QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Powdercoat - 1 White Gl(A)- B4B	4	12/23/19	0.00	0.17	Powdercoat - 1 - B4B	
	pcs					Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160	QC 3	4	12/23/19	0.00	0.00	QC 3 - 10	
	pcs					QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	

DAS
81
9-89170 Packaging 3-1 - Stock - B4B 4
pcs 12/23/19

0.00 0.00

QC 3 - 40
QC 3 - 19
QC 3 - 43
QC 3 - 24
QC 3 - 61
QC 3 - 81

DEC 30 2019

Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4BDAS
28
9-89

180 QC 21 - SA

4
pcs

12/23/19

0.00 0.00

QC 21 - SA - 21
QC 21 - SA - 70
QC 21 - SA - 53

JAN 03 2020

51407

Part Op 100 - (HAAS CNC Vertical Machine) Program batch number Machine Step No 1 as per Folio FA534 and visually inspect
 Descriptions: as per Dwg D2920 & attached Dimension Sheet Machine Step No 2 as per Folio FA534 and visually inspect as per Dwg
 D2920 & attached Dimension Sheet Machine Step No 3 as per Folio

110 - (Manufacture as per dwg) Machine Keyway and inspect per Dwg D2920 & attached dimension sheet
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 145 - (QC3- Inspect Part Finish)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6102-010	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	S236580x4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6102-010	4	0	0

Part Specifications

Specifications could not be found

Gave Control
to over

Lajeunesse, Marie

DART AEROSPACE LTD		Work Order: 202869
Description: Inner Saddle		Part Number: D2920-1
Inspection Dwg: D2920 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	1.240	1.260	✓	1.250	1.250	1.250		
B	Ø0.437	Ø0.443		0.438	0.438	0.438		
C	0.490	0.510		0.501	0.502	0.502		
D	1.745	1.755	✓	1.750	1.750	1.750		
E	3.495	3.505	✓	3.500	3.500	3.500		
F	1.745	1.755	✓	1.750	1.750	1.750		
G	7.990	8.010	✓	7.996	7.998	7.998		
H	0.514	0.534		0.528	0.528	0.528		
I	0.090 x 45°	0.110 x 45°		0.100 x 45°	0.105	0.105		
J	1.510	1.525		1.510	1.510	1.510		
K	0.175	0.205		0.191	0.191	0.190		
L	R0.178	R0.198	✓	0.188	0.188	0.188		
M	0.225	0.255		0.245	0.246	0.245		
N	R0.490	R0.510		0.500	R0.50	0.500		
O	0.740	0.760	✓	0.756	0.756	0.756		
P	3.495	3.535	✓	3.525	3.525	3.520		
Q	0.315	0.335		0.335	0.339	0.330		
R	0.180	0.220		0.210	0.220	0.220		
S	1.762	1.782		1.780	1.778	1.775		
T	0.250	0.270		0.258	0.258	0.258		
U	4.436	4.446	✓	4.441	4.441	4.441		
V	1.498	1.508	✓	1.503	1.503	1.503		
W	1.498	1.508	✓	1.503	1.503	1.503		
X	0.713	0.733		0.725	0.730	0.730		
Y	1.278	1.288	✓	1.283	1.283	1.283		
Z	1.103	1.113	✓	1.108	1.108	1.108		
AA	1.225	1.235	✓	1.236	1.230	1.230		
AB	1.225	1.235	✓	1.230	1.230	1.230		
AC	Ø0.256	Ø0.262	✓	0.258	0.258	0.258		
AD	R0.490	R0.510	✓	R0.500	R0.500	0.500		
AE	0.225	0.255		0.240	0.247	0.230		
AF	0.760	0.765	✓	0.760	0.760	0.760		
AG	0.308	0.312		0.311	0.311	0.311		
AH	2.050	2.055		2.055	2.055	2.055		
AI	0.615	0.635		0.626	0.624	0.624		
AJ	1.240	1.260		1.250	1.250	1.250		
AK	0.352	0.372		0.362	0.362	0.362		

Accept/Reject

reject

Measured by: JBL 57

Date: 19/12/12

Audited by: [Signature] 9-89

Date: 19/12/13

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM	
B	08.04.21	Reformat	KJ/JLM	[Signature]

Entered: LRDate: Jan 9/20NCR No. 20-7848

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>202 869</u> Part No. <u>D2920-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>19/12/12</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>			MRB (QSI042)		
Description Work Order Deviation				Disposition				<u>PD 19-12-12</u>	
<u>→ T4 (1" iscar ball insert)</u> <u>→ the bolt that hold T4 have loss</u> <u>so the tool have drop in the pieces.</u>				<u>Scrap and destroyed.</u> <u>no replace.</u>				Completed By <u>SB2. 19/12/12</u>	
								Lead hand / Supervisor <u>only</u> <u>19/12/12</u>	
								QC / QA Coordinator <u>PD 19-12-12</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☒ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						Other/Details:	